

Date: Tuesday, 03/10/2006 11:48:55 AM
User: Linda Lacelle







Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 28822	
Estimate Number : 12543	
P.O. Number :	Part Number : D35381
This Issue : 03/10/2006 S.O. No. :	Drawing Number : D3538 UNDER REV
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : UNDER REVIEW
Previous Run :	Material :
Written By :	Due Date : 10/10/2006 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 06-10.03 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
		
Comment: Qty.: 0.1995 f(s)/Unit Total: 0.3990 f(s) 6061_T6 Bar 0.750 x 1.500 Batch: <u>M15031</u> <i>Ed. 10.03</i>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: 1-Machine as per Folio FA651 and Dwg D3538 2-Deburr <i>Ed. 10.03</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>Ed. 10.03</i>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <i>SA 06.10.04</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>Ed. 10.04</i> (2)		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/10/2006 11:48:55 AM
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Process Sheet

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Drawing Name: HINGE BRACKET

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q M 06-10-04

(2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 04

(2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06-10-06

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u de 10-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

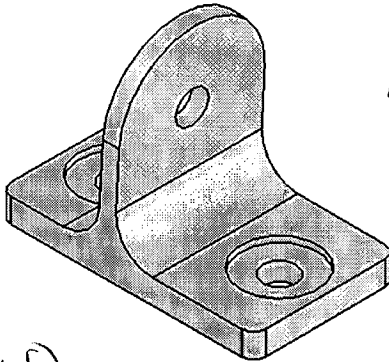
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

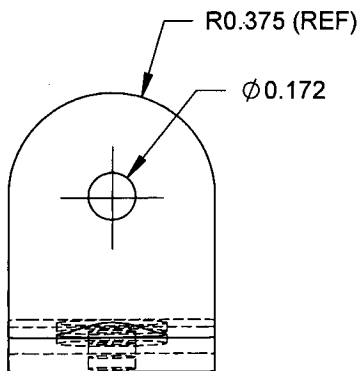
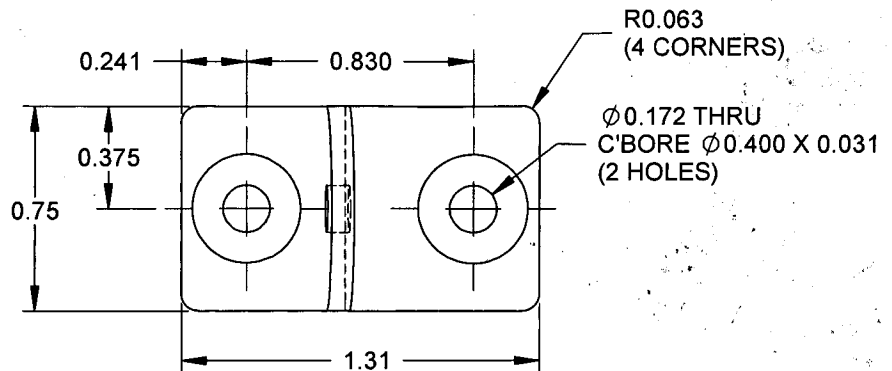
PRELIMINARY ISSUE

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3538	REV. A SHEET 1 OF 1
DATE 06.09.05	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.09.05	DESCRIPTION NEW ISSUE	

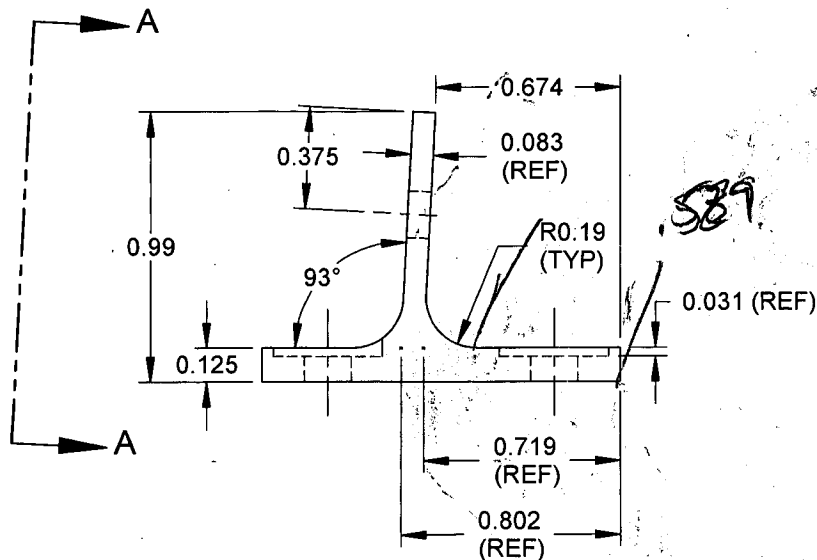
UNDER REVIEW
06.07.18 LE



*MISOSI
6061 T6 1.50 X .75*



AUXILIARY VIEW A



D3538-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

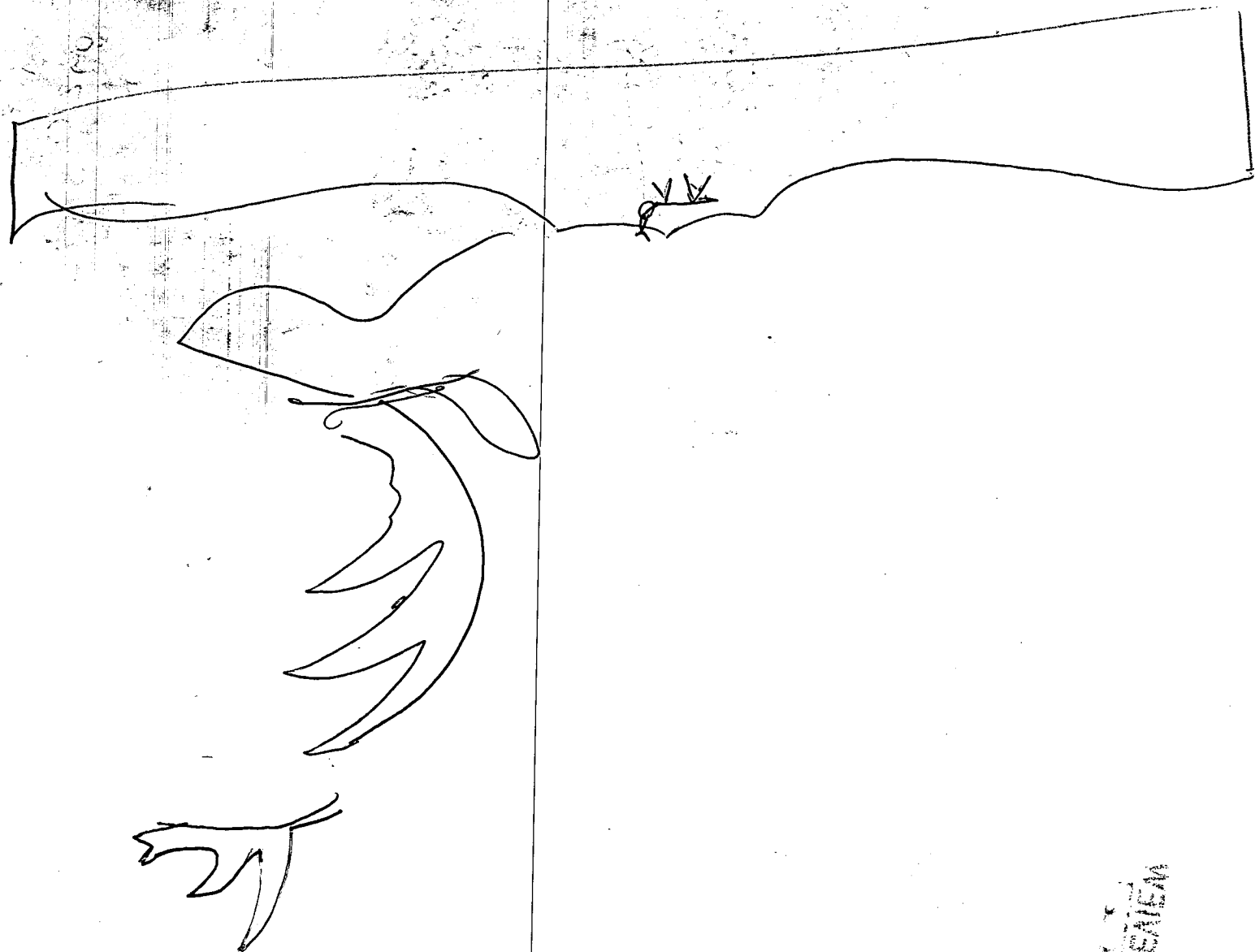
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*0.260
+ .135
11.01
26.46
16.32
29.00*

*5.85
6.*

*10.50
25.71
10.83
25.10*



WATER

DART AEROSPACE LTD		Work Order:
Description:		Part Number: D3538-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.830	± 0.005	0.832	✓			
R.063	± 0.01	R.063	✓			
ϕ .172	± 0.005	ϕ .172	✓			
1.31	± 0.03	1.312	✓			
0.750	"	0.751	✓			
0.375	± 0.005	0.374	✓			
0.241	"	0.244	✓			
0.083	± 0.01	0.090	✓			
R.19	"	R.187	✓			
0.031	"	0.032	✓			
0.125	"	0.126	✓			
0.99	± 0.03	0.993	✓			
0.375	± 0.005					
93°	$\pm 0.5^\circ$	93°	✓			
0.375	± 0.005	0.374	✓			
0.674	± 0.01	0.668	✓			

Measured by: <i>RE</i>	Audited by: <i>SD</i>	Prototype Approval:
Date: 06.10.03	Date: 06.10.04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	